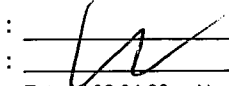
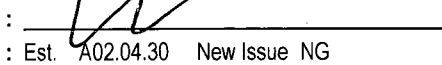


Date: Friday, 10/12/2007 1:11:52 PM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOUBLER
Job Number :	35155		
Estimate Number :	11461		
P.O. Number :		Part Number :	D314087
This Issue :	10/12/2007	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3140 REV F
First Issue :	/ /	Project Number :	N/A
Previous Run :	27345	Drawing Revision :	F
	Type :	Material :	
	SMALL /MED FAB	Due Date :	10/19/2007
Written By :		Qty:	<u>8</u> Um: Each
Checked & Approved By :			
Comment :	Est. A02.04.30 New Issue NG Est. Rev B New dwg rev. ecn781 06.04.18 EC Est. rev.C added scuffing NCR 061 EC Est Rev:B As per ECN #829 06-11-20 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S032	2024-T3 .032 sheet
-----	-------------	--------------------



Comment: Qty.: 2.1966 sf(s)/Unit Total : 4.3932 sf(s)
 2024-T3 .032 sheet
 Matl: 2024-T3 (QQ-A-250/4) .032" thick
 (M2024T3S.032) (43" x 7" ref)
 Batch M10SS55 B07-10-15

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
 Cut as per dwg D3140

water Seal. B07-10-15

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Scuff surfaces with 80grit sandpaper per QSI 006
 2-Deburr. B07-10-15
 No sharp edges

SAD

07-10-15

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

Er 07/10/15 (x8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

Friday, 10/12/2007 1:11:52 PM
Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 35155

Part Number: D314087

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 07/10/16 (8)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/10/16 (8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FL 07/10/16 (8)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.16

Job Completion



FL 07.10.16

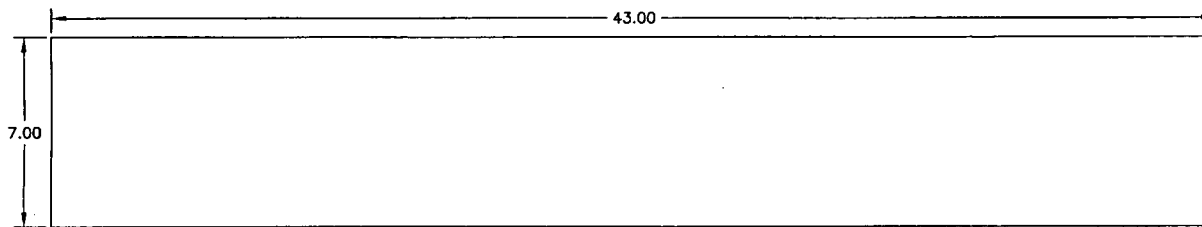
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

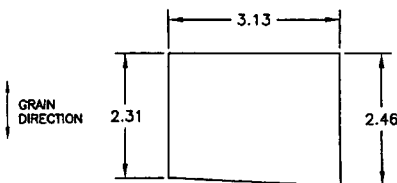
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

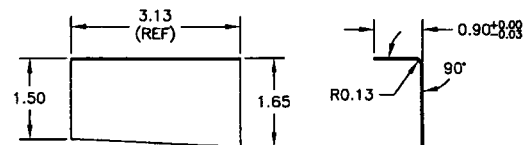
NOTE: Date & initial all entries



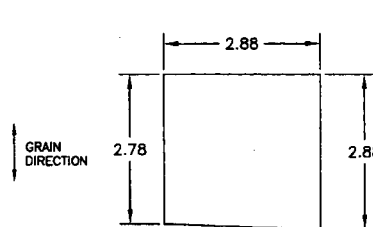
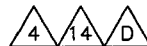
D3140-87 DOUBLER
(REPLACES PREMIER P/N B30-23000-87)



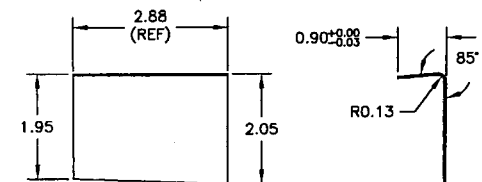
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



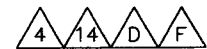
D3140-105 DOUBLER
D3140-106 OPPOSITE



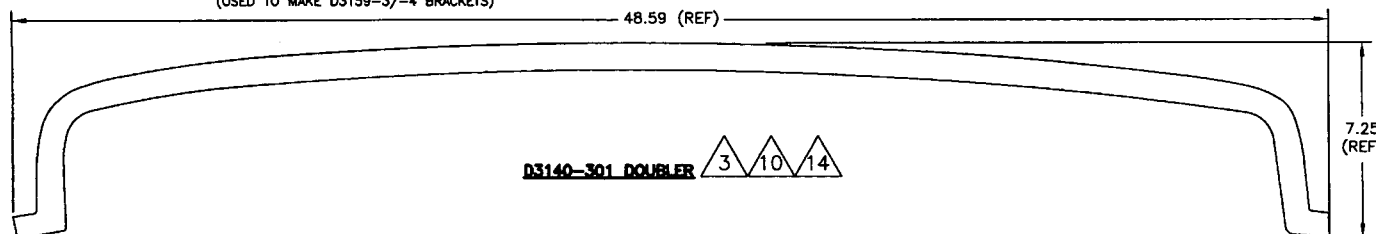
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



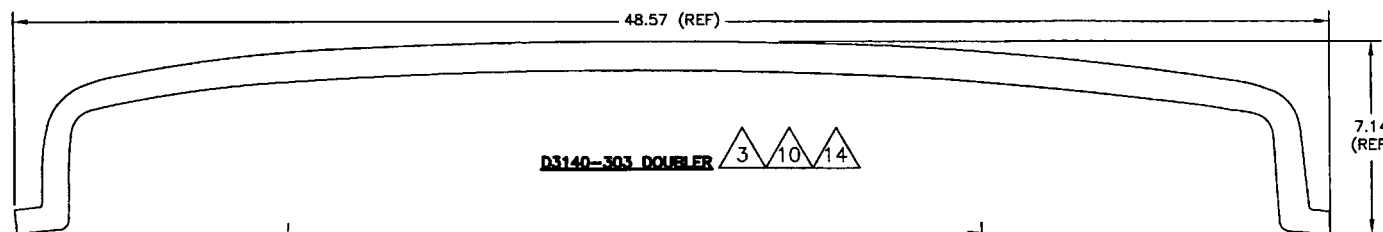
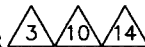
D3140-104 DOUBLER
D3140-103 OPPOSITE



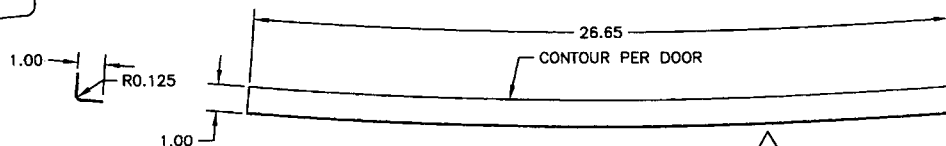
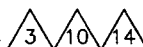
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER



D3140-303 DOUBLER



D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

RELEASED

06.11.13

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DESIGN	4	DRAWN BY	CB	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO.	REV. F
DATE	06.10.06	TITLE	DOOR	D3140	SHEET 6 OF 7
		SCALE	NTS		

